

Date: Thursday, 5/4/2006 11:19:32 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BLOWER MOTOR SUPPORT
Job Number : 26989	
Estimate Number : 12309	
P.O. Number : N/A	Part Number : D3471043
This Issue : 5/4/2006 S.O. No. : N/A	Drawing Number : D3471 REV.A
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : SMALL / MED FAB	Drawing Revision : A
Previous Run : 26611	Material : N/A
Written By : <u>SEE COMMENT BELOW</u>	Due Date : 5/28/2006
Checked & Approved By : <u>06.05.05</u>	Qty: <u>4</u> Um: Each
Comment : est rev A 06.03.02 New issue EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	MS3584216	CLAMP
-----	-----------	-------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)
 pick:

Qty	Part number	Description	Batch
1	MS35842-16	CLAMP	<u>M10076</u>

FF 06.05.15

4

2.0	MS20427M44	RIVET
-----	------------	-------



Comment: Qty.: 3.0000 Each(s)/Unit Total : 24.0000 Each(s)
 pick:

Qty	Part number	Description	Batch
3	MS20427M4-4	Rivet	<u>M100393</u>

FF 06.05.15

4

3.0	D34713	SUPPORT
-----	--------	---------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)
 pick:

Qty	Part number	Description	Batch
1	D3471-3	Support	<u>B26126</u>

FF 06.05.15

4

4.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------






Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per dwg D3471

FF 06.05.15

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
06.05.15	4	1 Bracket D3471-3 2 clamps MS35842-16 bit ovalized hole in bracket during transfer drilling. At into S.S.		scrap 2 Destroy scrap 3 Destroy	FF 06.05.15 FF 06.05.15			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA:  Date: 06/05/23

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Thursday, 5/4/2006 11:19:32 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BLOWER MOTOR SUPPORT

Job Number: 26989

Part Number: D3471043

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC5

INSPECT WORK TO CURRENT STEP



260516 (4)

Comment: INSPECT WORK TO CURRENT STEP

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *GA*

SS 06/05/17 (4)

7.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/05/19 (4)

Job Completion



U 06-05-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

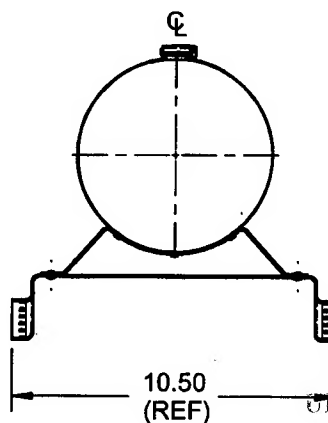
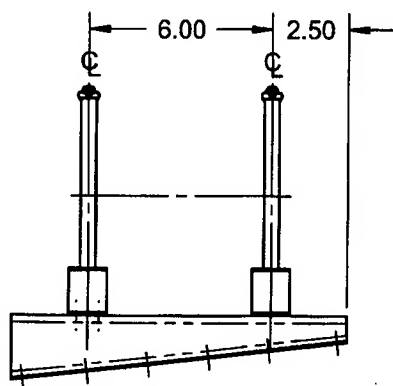
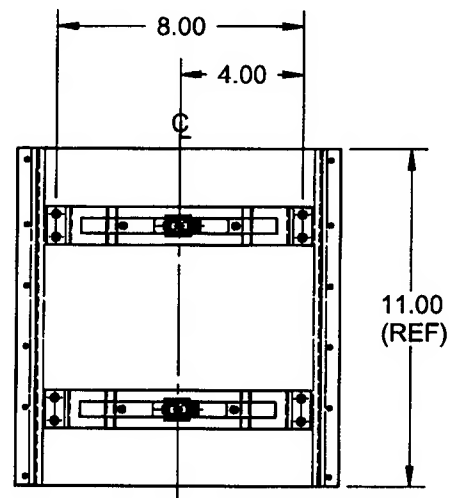
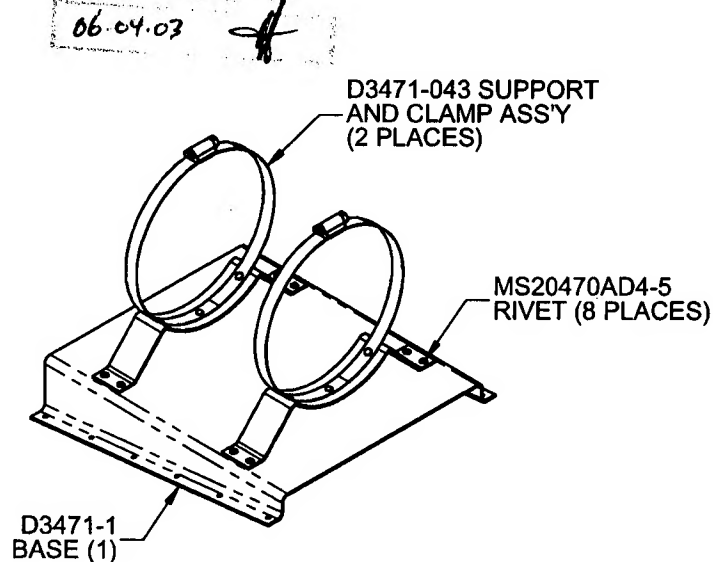
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3471	REV. A SHEET 1 OF 5
DATE 05.12.21		TITLE BLOWER MOTOR SUPPORT	SCALE 1:6
A	05.12.21	NEW ISSUE	



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 26989

D3471-041 BLOWER MOTOR SUPPORT

NOTES:

- 1) IDENTIFY WITH DART P/N D3471-041 USING FINE POINT PERMANENT INK MARKER
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

QTY -041	P/N	DESCRIPTION
X	D3471-041	BLOWER MOTOR SUPPORT
2	D3471-043	SUPPORT AND CLAMP ASSEMBLY
1	D3471-1	BASE
8	MS20470AD4-5	RIVET

COPYRIGHT © 2005 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



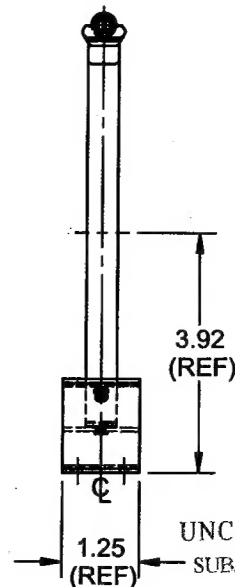
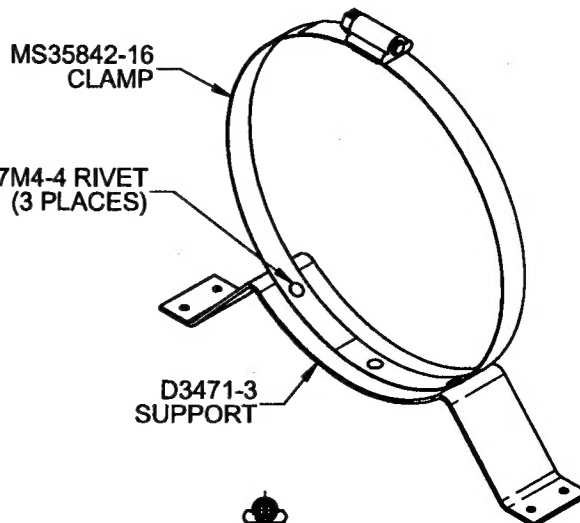
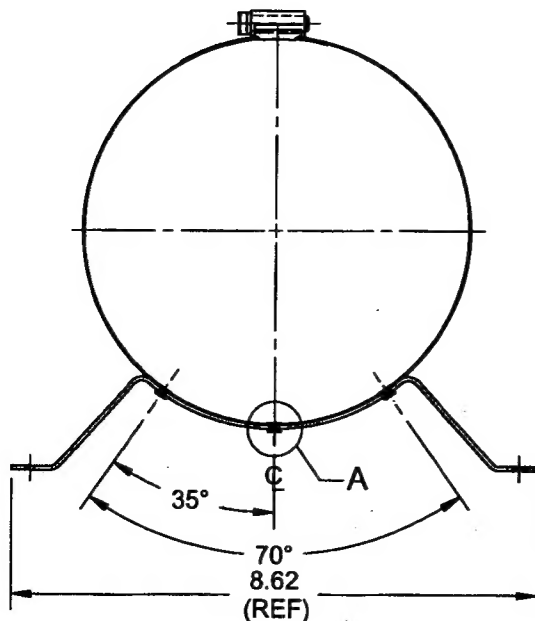
DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3471	REV. A
DATE 05.12.21		TITLE BLOWER MOTOR SUPPORT	SHEET 2 OF 5 SCALE 1:3

06.04.03 *[Signature]*

LOCATE AND TRANSFER DRILL
#30 ($\phi 0.129$) THRU HOLE FROM
D3471-3 TO MS35842-16 CLAMP
AND C'SINK $\phi 0.230 \times 100^\circ$
(3 PLACES)



DETAIL A: COUNTERSINK HOLES
(RIVET NOT SHOWN FOR CLARITY)
SCALE 1:1



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 26989

D3471-043 SUPPORT & CLAMP ASS'Y

NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010

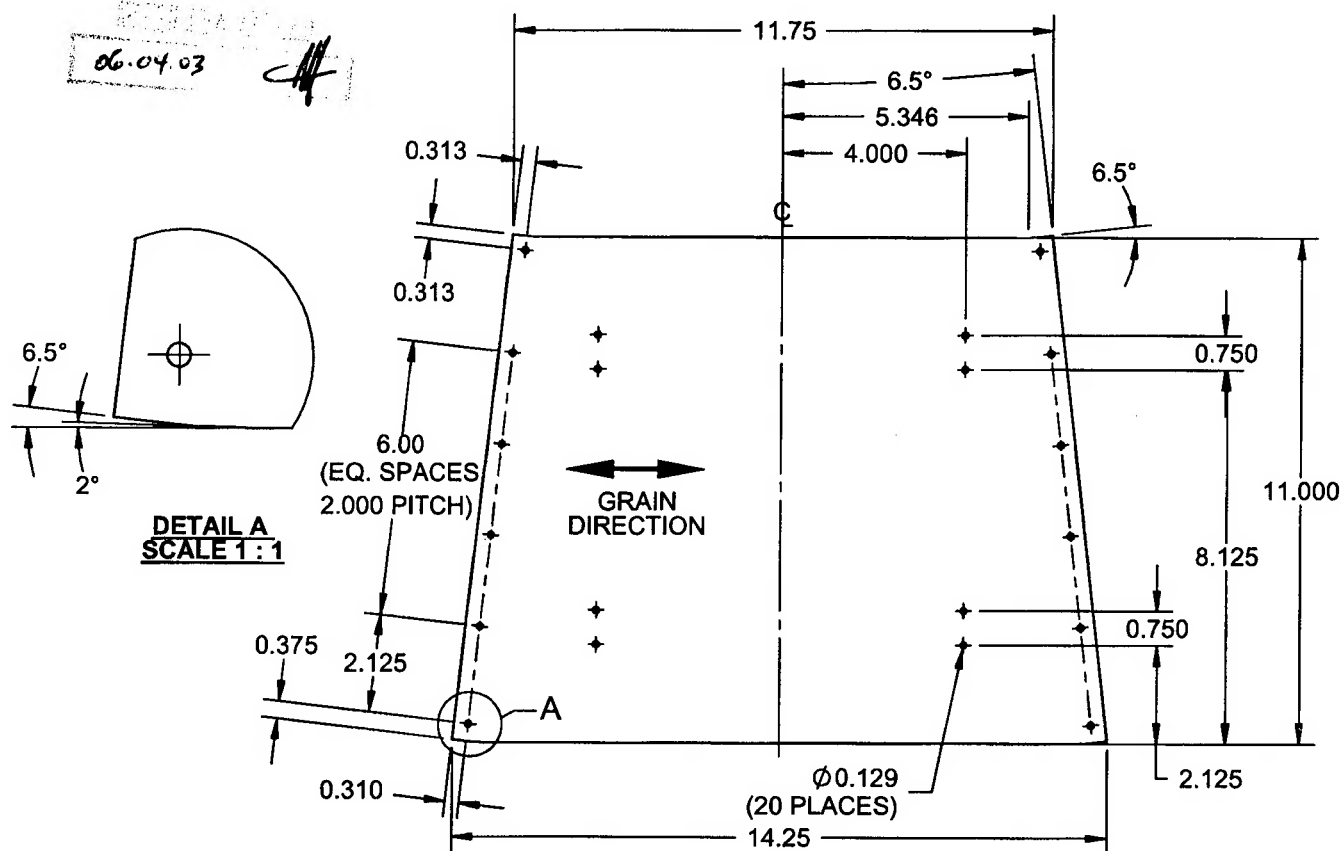
QTY -043	P/N	DESCRIPTION
X	D3471-043	SUPPORT AND CLAMP ASSEMBLY
1	D3471-3	SUPPORT
3	MS20427M-4	RIVET
1	MS35842-16	CLAMP

COPYRIGHT © 2005 BY DART AEROSPACE LTD.

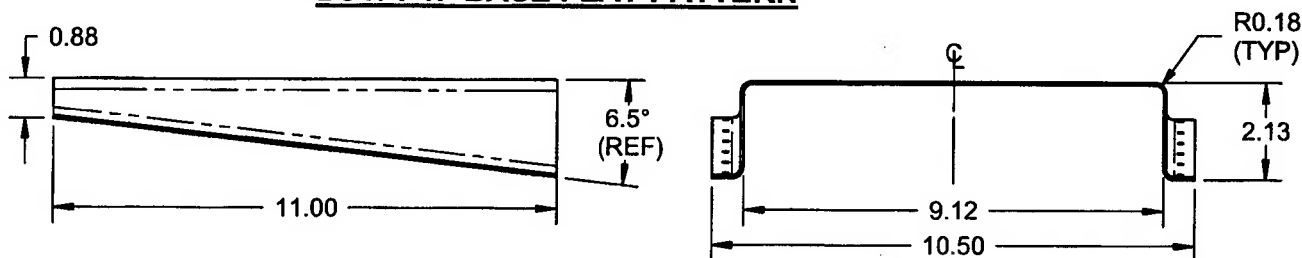
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

DART

DESIGN B	DRAWN BY B	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3471	REV. A SHEET 3 OF 5
DATE 05.12.21		TITLE BLOWER MOTOR SUPPORT	SCALE 1:4



D3471-1F BASE FLAT PATTERN



D3471-1 BASE BENDING DETAIL

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET (0.063" THICK)
PER QQ-A-250/4 OR AMS 4037
(REF. DART SPEC. M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) PART IS SYMMETRICAL ABOUT CENTER LINE
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

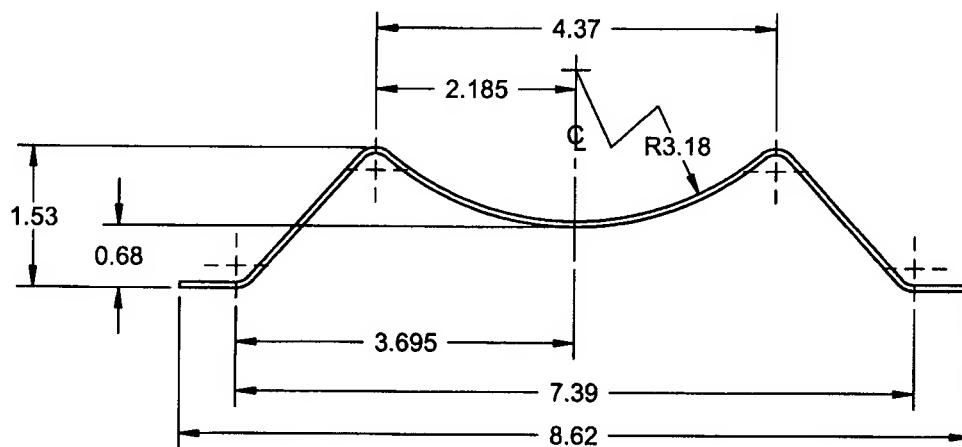
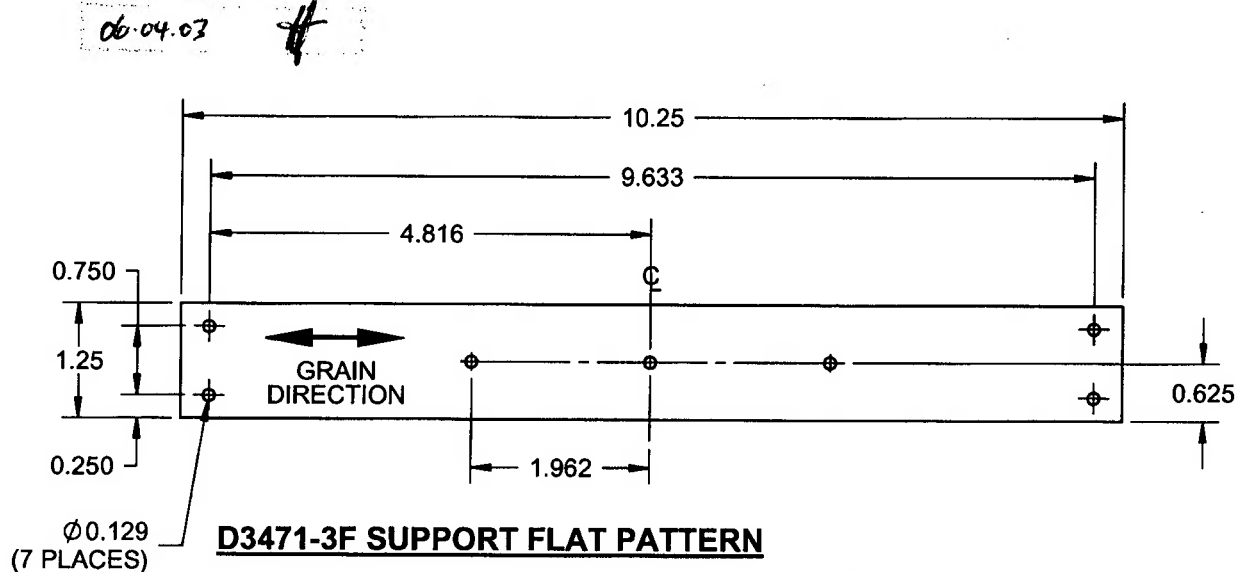
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 26989

COPYRIGHT © 2005 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3471	REV. A
DATE 05.12.21		TITLE BLOWER MOTOR SUPPORT	SCALE 1:2
		SHEET 4 OF 5	



NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET (0.063 THICK)
PER AMS-QQ-A-250/4 OR AMS 4037
(REF. DART SPEC. M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 2) PART IS SYMETRICAL ABOUT CENTER LINE
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 26989

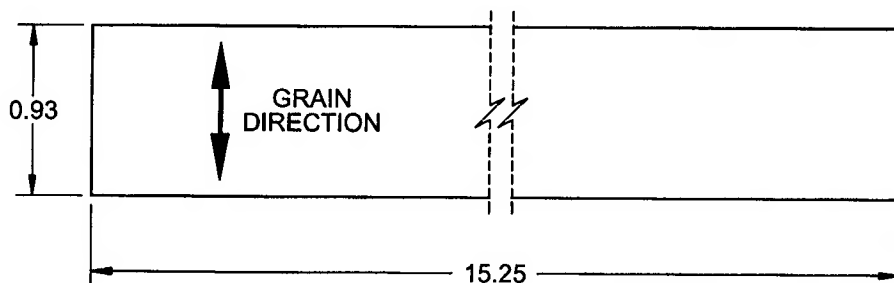
COPYRIGHT © 2005 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

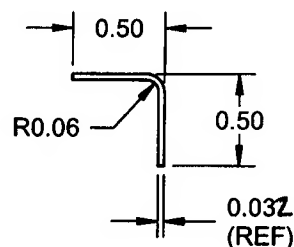


DESIGN <i>B</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>A</i>	APPROVED <i>A</i>	DRAWING NO. D3471	REV. A SHEET 5 OF 5
DATE 05.12.21		TITLE BLOWER MOTOR SUPPORT SCALE 1:1	

06.04.03 *A*



D3471-5F STIFFENER FLAT PATTERN



**D3471-5 STIFFENER
BENDING DETAIL**

D3471-5 STIFFENER

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET (0.032" THICK)
PER QQ-A-250/4 OR AMS 4037
(REF. DART SPEC. M2024T3S.032)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 26989

COPYRIGHT © 2005 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.